

Date: Monday, 2/19/2007 8:07:58 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	GASKET	
Job Number	30756				
Estimate Number	12714				
P.O. Number	N/A		Part Number	D353639	
This Issue	2/19/2007	S.O. No.	N/A	Drawing Number D3536 UNDER REVIEW <i>Rev A</i> <i>07.02.19</i>	
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A	Type	SMALL /MED FAB	Drawing Revision	U/R
Previous Run			Material	N/A	
Written By			Due Date	2/26/2007	Qty: 12 Um: Each
Checked & Approved By	<i>07.02.19</i>				
Comment	Est Rev:A New Issue 07-02-14 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MNEO60S063	NEOPRENE SHEET 0.063 Comment: Qty.: 0.7911 sf(s)/Unit Total : 9.4928 sf(s) NEOPRENE SHEET 0.063 Batch: <i>M103104</i> <i>SAD 07/03/10</i>
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3536 Dwg Rev: <i>A</i> Prog Rev: <i>A</i> 2-Deburr if necessary <i>SAD 07/03/10</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>SAD 07/03/10</i>
4.0	QC8	SECOND CHECK Comment: SECOND CHECK <i>07/03/12</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ <i>07/03/13</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 30756

Part Number: D353639

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

F D67103/14

Job Completion



U 87,83/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

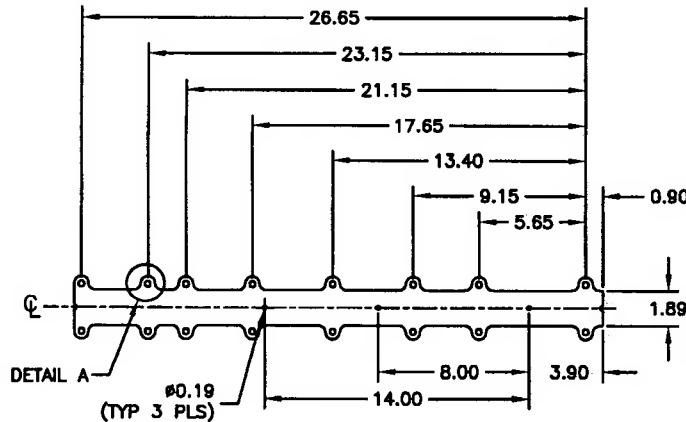
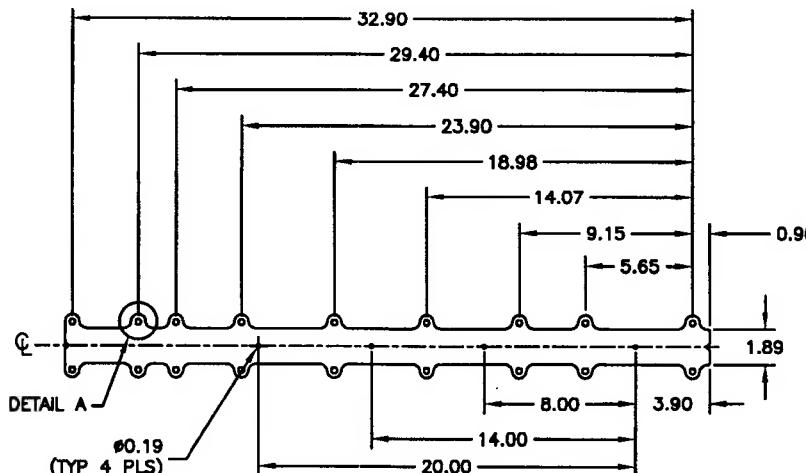
NOTE: Date & initial all entries

DART

09.02.12-1

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED JH	DRAWING NO. D3536
DATE 06.10.25		TITLE GASKET

REV. A
SHEET 1 OF 6
SCALE
1:10

**D3536-11 GASKET****D3536-13 GASKET****NOTES**

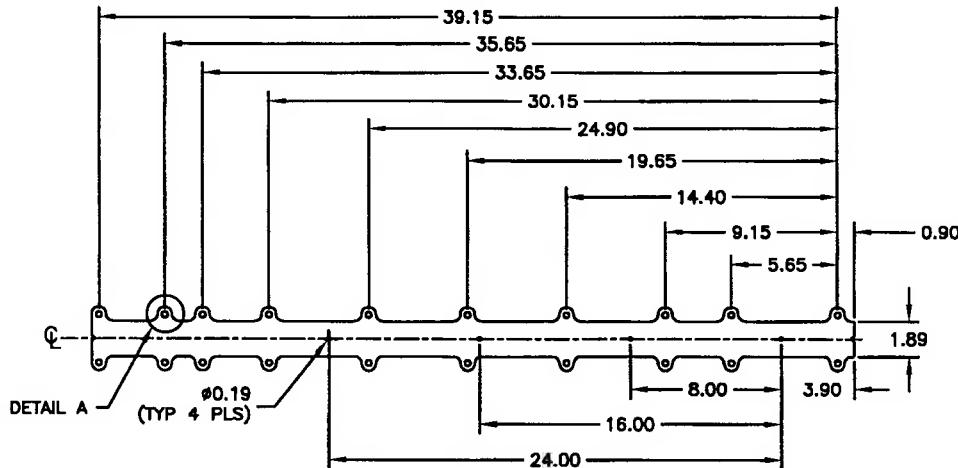
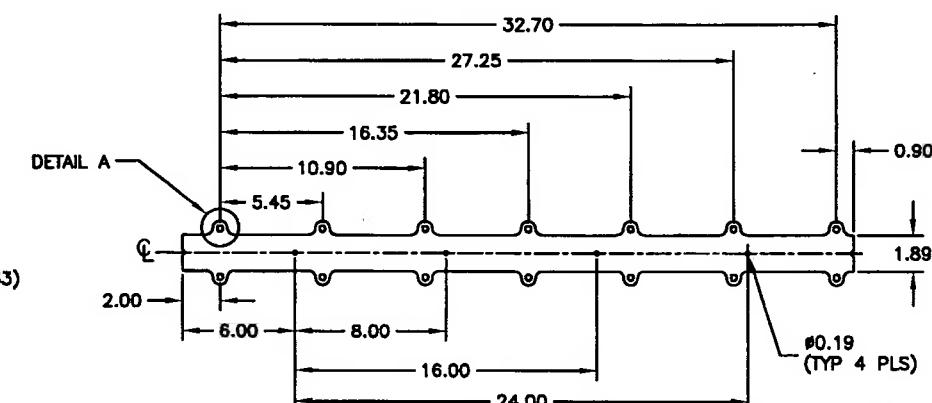
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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WORK ORDER
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DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PW	APPROVED MH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 2 OF 6 SCALE 1:10

RELEASER
07.02.12

**D3536-15 GASKET****D3536-21 GASKET**

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NOTES

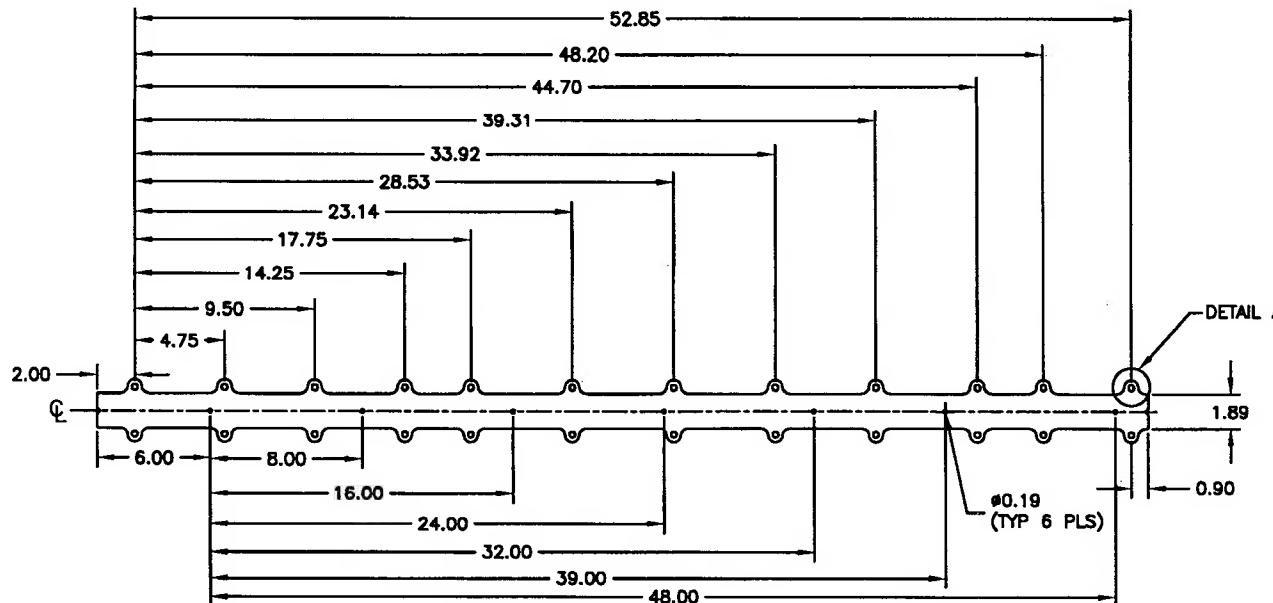
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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CHECKED PH	APPROVED SH	DRAWING NO. D.3536
DATE 06.10.25		TITLE GASKET

REV. A
SHEET - 3 OF 6
SCALE
1:10

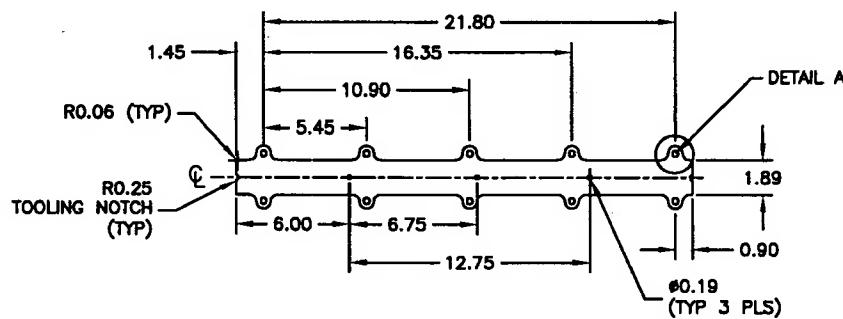
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**D3536-23 GASKET**

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NOTES

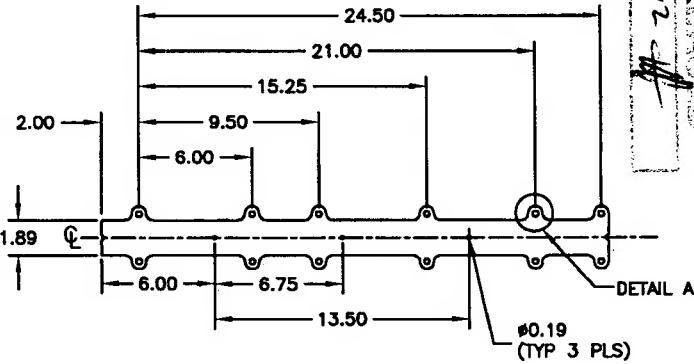
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

**D3536-25 GASKET**

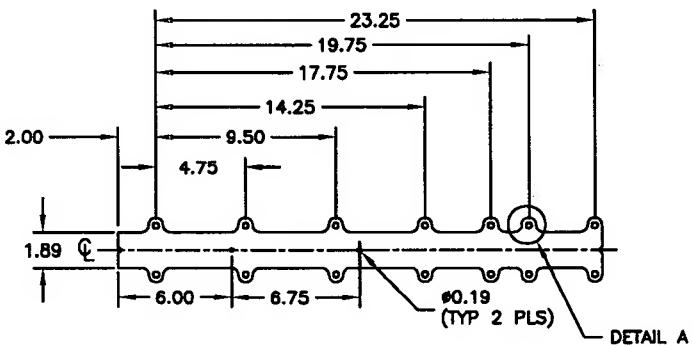
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DESIGN C.B	DRAWN BY C.B	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED MH	APPROVED MH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 4 OF 6 SCALE 1:10

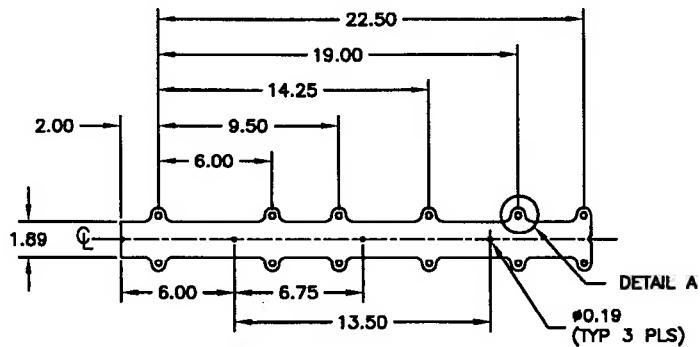
07.02.12 *[Signature]*



D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

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WORK ORDER
NO. *30754*

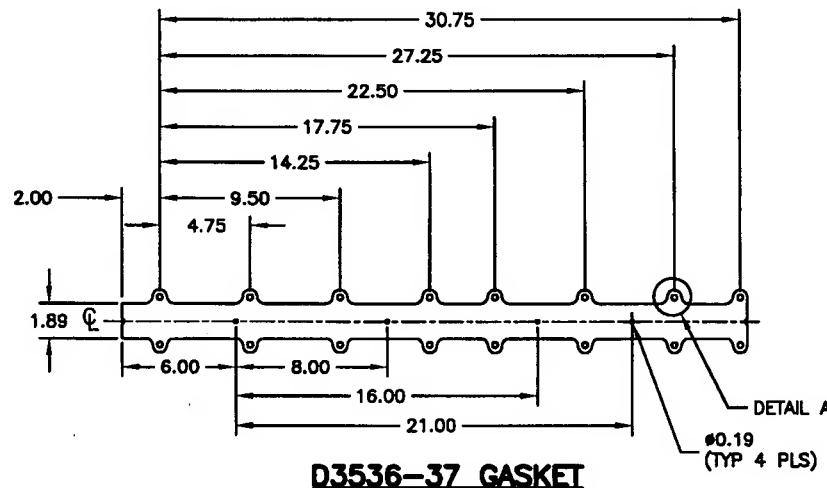
NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DART

07.02.02
H

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C8	C8	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
P4	H	D3536
DATE		TITLE
06.10.25		GASKET
SHEET 5 OF 6		SCALE
		1:10

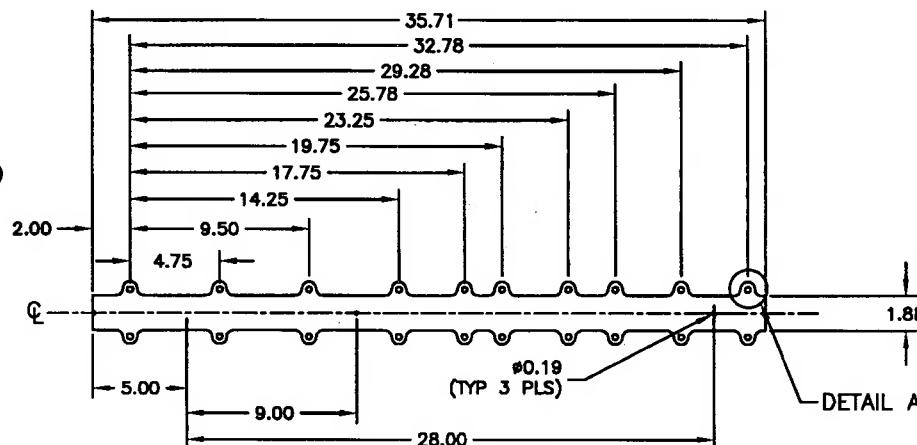


D3536-37 GASKET

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WORK ORDER
NO. 30456

NOTES

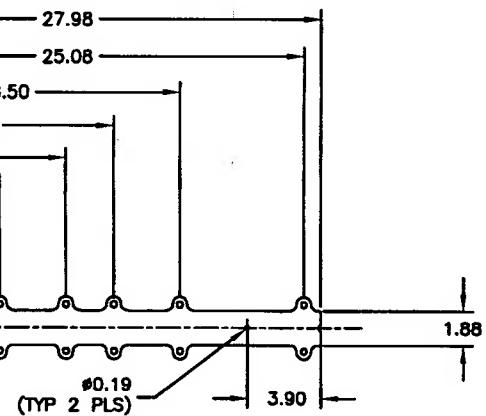
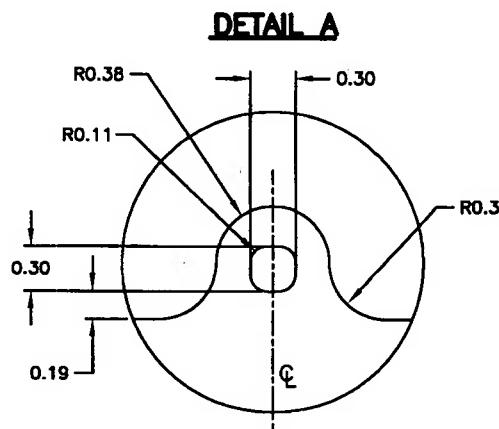
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-39 GASKET

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DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED M	APPROVED M	DRAWING NO. D3536
DATE 06.10.25		TITLE GASKET
SCALE 1:10		REV. A SHEET 6 OF 6

07.02.12 *[Signature]***D3536-41 GASKET**

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WORK ORDER NO. 2075

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

DART AEROSPACE LTD	Work Order:	30756
Description: Gasket	Part Number:	D3536-39
Inspection Dwg: A Rev: A	.	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
35.71	+/- 0.030	35.71	/		M-T	
32.78	+/- 0.030	32.75	/		M-T	
29.28	+/- 0.030	29.25	/		" M-T	
25.78	+/- 0.030	25.75	/		M-T	
23.25	+/- 0.030	23.25	/		M-T	
19.75	+/- 0.030	19.75	/		M-T	
17.75	+/- 0.030	17.75	/		MT	
14.25	+/- 0.030	14.25	/		M-T	
9.50	+/- 0.030	9.480	-		Vern	
4.75	+/- 0.030	4.729	-		Vern	
1.88	+/- 0.030	1.89	-		Vern	
Ø 0.19	+/- 0.030	Ø 0.20	/		Vern	
0.300	+/- 0.030	0.30	/		Vern	
0.300	+/- 0.030	0.30	/		Vern	
0.063	+/- 0.010	0.060	/		Vern	

Measured by:	SAM
Date:	07/03/10

Audited by:	<u>M</u>
Date:	<u>07/03/12</u>

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	